

Order ID 124754

124754

33 September-23-14 7:41:47 AM

Page-1

Item ID: D3192-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pod Assembly
 Start Date: 9/23/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 10/31/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MUS Date: 14-09-23 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3192	C								

100 0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 25000

Description:

D2200-1 Pod Lid

D2200-3 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required.

CEL 14/109/23 ①

110

Receive & Inspect for Damage & Mat'l Ceris

0.00

110

Packaging

Memo

0.00

Packaging

Encure Certificate of Conformity and Process sheet from Delastek is attached.

IX 14/12/1 SP

IX 14-12-1 SP

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Item ID: D3192-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 9/23/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/31/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Check for void spot and pins Check over all dimensions as per Dwg. D2200.								
130		0.00							
130									
Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
	Drill hinge center on lid and base as per dwg D3192								
	Drill backer plate holes using DT9914								
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control									

SMP
14/12/22

SMP
14/12/22

Pto

14-12-24
14-12-23

DAS
9
9-89

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Item ID: D3192-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pod Assembly
 Start Date: 9/23/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/31/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3192								
160		0.00							
160	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

Ships
14/12/22

14-12-23
DAS
9
9-89

Ships
14/12/22

QA:

Date:

DART
AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only ☐

Work Order: <u>124754</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>153192-042</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>15-4714</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-12-04	30	1	Holes for 02195, 02196 and 02197 Bracket Assy's drilled on left wrong side	A.P. 14.12.05	under cut foam between inner and outer sleeve and fill void with Hysol 93464		Shp 14/12/00	S 15/12/02
Doc/Data				RL operate Energy		and smooth + re-prime inside of part. Re-shot	AS 14-12-05		
Equip/Tooling				operate trans	B130558	white gel coat on outside + blend with buffing	AT 14-12-00		
Handling/Pre									
Material									
Operator									
Offsite/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Other	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
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operate Trans / no work
Done before Drill

DCA:

Date: 13/03/20

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACEQA Closed: BAWDate: 15/03/20Work Order update only ☐

Work Order: <u>124 754</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3192-042</u>	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. <u>15-4715</u>	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-12-01	Pro	1	gel coat cracked at top of pod base under neck 1st Flange Re machining of Product.	A.R. 14.12.05	sand off affected gel coat down to cloth + re shoot gel coat	14-12-10	14/12/02	5 15/01/12
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator <input checked="" type="checkbox"/>									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Over/Under Tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input checked="" type="checkbox"/> Other
		<u>Mis handling of Product.</u>

DCA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 15/03/20 Date: 15/03/20

Work Order update only ☐

Work Order: <u>124754</u> Part No. <u>D3,92-042</u> NCR No. <u>15-4716</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input checked="" type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input checked="" type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14/12/16	130	1	gel coat touch up	A.P.	sand + 85% paint	OK	Shrp	
Doc/Data				has pin holes	14.12.10	affected area	14.12.16	14/12/17	5
Equip/Tooling				in repair area		with white			15/11/12
Handling/Pre						8-moon 3.5			
Material						interior pad			
Operator									
Off-set/Setup									
Process									
Supplier	14/12/16	130	1	Replace End		D392-170			
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DQA:

Date: 15/03/26

WORK ORDER NON-CONFORMANCE / UPDATE

DART
AEROSPACE

OA Closed:

Date: 15/03/26

Work Order update only ☐

Work Order: 124754	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. 123192-012	Rework <input checked="" type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input checked="" type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. 15-4717	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.12.15	130	23	Holes for 03191-3	AP.	Countersink holes	Shp		
Doc/Data				backer plate drilled	14.12.15	on inside + outside of pod	14/12/20		
Equip/Tooling				at a 90° rotation		Fill holes with			
Handling/Pre				PL operat trans /		hycol 934 and 10%			
Material				no Reverser in setup		milled fiber / allow			
Operator				Before install.		sand flush			
Offset/Setup						Se-Prime / + paint on			
Process						Per QSP 005			
Supplier						re drill holes in proper			
Training	X					location + orientation	14/12/17		
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General		Other	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input checked="" type="checkbox"/> Other	
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	No Re-verified on Training Compliance		
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	Before work		
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence			

DQA: _____ Date: _____

DART
AEROSPACE**WORK ORDER NON-CONFORMANCE / UPDATE**QA Closed: 15/03/20 Date: 15/03/20Work Order update only ☐

Work Order: <u>124754</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>103192-042</u>		Skid-tube <input type="checkbox"/>	Crosstube <input checked="" type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>15-4718</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
<u>15-4719</u>		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.12.17	130	x1	During re-paint	A.P.	Send to re paint	AK	Shif	
Doc/Data				Fish eyes were discovered	14.12.17		14.12.17	14/12/17	S
Equip/Tooling									15/1/12
Handling/Pre									
Material				silicon contamination					
Operator				Re not clean only					
Offset/Setup									
Process									
Supplier	14/12/17	130	30	Replace bolt H73-11A	A.P.	H73-11A x30	Shif	S	S
Training				by H73-10A bolt	14.12.17	17137466	14/12/17	15/1/12	15/1/12
Transport				was too long		ENSURE 2 THREADS MIN			
Unapproved						PAST END OF LOT			

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 124754***124754***

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Item ID: D3192-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pod Assembly
Start Date: 9/23/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/31/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

ML5 14-12-24

CMF
14-12-24

Picklist Print

Page 1

September-23-14 7:41:44 AM

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 08.07.17 DL
IPP rev:B 09-02-05 rev.B as per dwg DD verified by:EC IPP revC
11.07.21 revC dwg EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AD64AES		Purchased	No				Each	562.0000	38	38		DAS 27 8-29	
AD64ARS									**				
Pop Rivet													

Location	Loc Qty	Loc Code
st268	562	
123969	27	
125147	58	
M126728	477	

AN3-11A		Purchased	No				Each	497.0000	30	30		DAS 27 8-29	
AN3-11A									**				
Bolt													

Location	Loc Qty	Loc Code
ST349	497	
123185	10	
m125709	253	
m130005	234	

AN3-5A		Purchased	No				Each	387.0000	30	30		DAS 27 8-29	
AN3-5A									**				
Bolt													

Location	Loc Qty	Loc Code
ST350	387	
117423	6	
124561	2	
m126559	92	
m129507	91	
m130325	196	

Picklist Print

September-23-14 7:41:44 AM

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

AN4-11A

Purchased

No

150

Each

374.0000

6

6

AN4-11A

BOLT

**

DAS

27

5-89

14/12/12

Location

Loc Qty

Loc Code

FG

20

120731

20

ST356

182

M128362

182

ST514

172

M126333

5

M127376

58

M128769

109

6

AN4-5A

Purchased

No

150

Each

343.0000

13

13

AN4-5A

BOLT

**

DAS

27

5-89

14/12/12

Location

Loc Qty

Loc Code

CA

59

m129682

59

ST355

284

120562

180

15247

4

m127817

100

13

AN4-6A

Purchased

No

130

Each

1,780.0000

1

1

AN4-6A

BOLT

**

DAS

27

5-89

14/12/12

Location

Loc Qty

Loc Code

ST355

428

16067

4

M128403

424

ST514

1352

M126317

350

M128634

1002

1

Picklist Print

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Page 3

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

AN526C632R7

Purchased

No

150

Each

200.0000

2

2

AN526C632R7

Screw

**

DAS

27

8-89

M/12/12

Location

Loc Qty

Loc Code

ST329

200

200

m129339

D2198-1

Manufactured

No

150

Each

4.0000

6

6

D2198-1

Bracket

**

8-8-8

27

DAS

M/12/12

Location

Loc Qty

Loc Code

ST001

4

4

80007

D2200-1

Manufactured

No

100

Each

0.0000

1

1

D2200-1

Pod Lid

**

B 124754

SP

D2200-3

Manufactured

No

100

Each

0.0000

1

1

D2200-3

Pod Base

**

B 124754

SP

D2204-6

Manufactured

No

150

Each

3.0000

3

3

D2204-6

Latch

**

8-8-8

27

DAS

M/12/12

Location

Loc Qty

Loc Code

ST479

8

8

67120

Picklist Print

Page 4

September-23-14 7:41:45 AM

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

D2204-9

Manufactured No

150 Each

11.0000

2

2

DAS

27

2-89

D2204-9

Rubber Latches

**

LocationLoc QtyLoc Code

ST119

11

107654

5

111010

2

113537

1

85081

3

BRG118

2

D2258-220

Manufactured No

150 Each

12.0000

1

1

DAS

27

2-89

D2258-220

Placard

**

LocationLoc QtyLoc Code

ST005

12

41266

4

84458

3

D2429-041

Manufactured No

150 Each

3.0000

1

1

DAS

27

2-89

D2429-041

Spring Clip Ass'Y

**

LocationLoc QtyLoc Code

ST008

8

107585

6

81895

2

D2463

Manufactured No

150 f

333.0137

14.167

15

DAS

27

2-89

D2463

1/2" Seal (\$Per Foot)

**

LocationLoc QtyLoc Code

ST409

333.013684

110718

25.063684

115701

357.95

121929

500

15

September-23-14 7:41:45 AM

Shop Packet Print

Page 4

Picklist Print

September-23-14 7:41:45 AM

Page 5

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

D2528-1 Manufactured No

150 Each 5.0000 5 5

D2528-1

Backer Plate

DAS
27
9-29

14/12/12

Location

Loc Qty

Loc Code

ST007

5

B113711

82334

5

D2528-3 Manufactured No

150 Each 0.0000 4 4

D2528-3

Backer Plate

DAS
27
9-29

14/12/12

D2569 Manufactured No

130 Each 3.0000 1 1

D2569

Hinge

DAS
27
9-29

14/12/12

Location

Loc Qty

Loc Code

CA

3

110818

2

113832

1

D3007-041 Manufactured No

150 Each 3.0000 1 1

D3007-041

Prop Assy

DAS
27
9-29

14/12/12

Location

Loc Qty

Loc Code

ST259

1

84300

1

ST358

2

110916

2

D4393-17 Manufactured No

100 Each 0.0000 1 1

D4393-17

Piano Hinge

DAS
27
9-29

14/12/12

K10019 Manufactured No

150 Each 0.0000 1 1

K10019

Bracket Assembly

DAS
27
9-29

14/12/12

September-23-14 7:41:45 AM

Shop Packet Print

Page 5

Picklist Print

September-23-14 7:41:45 AM

Page 6

Work Order ID: 124754

Parent Item: D3192-042

Parent Item Name: Pod Assembly

124754

D3192-042

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L06

Purchased

No

150

Each

592.0000

2

2

DAG

27

8-89

11/12/12

MS210421 06

Nut

**

Location

Loc Qty

Loc Code

ST306

200

m130325

200

ST307

392

m127304

3

m128976

189

m129499

200

MS21042L3

Purchased

No

150

Each

2,214.000

60

60

DAG

27

8-89

11/12/12

MS210421 3

Nut

**

Location

Loc Qty

Loc Code

ST307

2214

123900

934

M127410

11

M127831

41

M128401

42

M128754

1186

M130799

60

Picklist Print

September-23-14 7:41:46 AM

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

150

Each

3,916.000

20

20

DAS
27
S-29

MS21042L 4

Locknut

**

14/12/2

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

3904

111827

2

126275

5

m126015

12

m126275

27

m127255

63

m127376

9

m127813

821

m128300

69

m128798

658

m129472

738

m129934

1500

20

NAS1149D0363J

Purchased

No

150

Each

2,277.000

60

60

DAS
27
S-29

NAS1149D0363.J

Washer

**

M/12/2

Location

Loc Qty

Loc Code

GA

7

124392

7

ST276

1005

m123441

5

m130358

1000

ST510a

1265

m128429

1265

M/12/3/9

60

Picklist Print

September-23-14 7:41:46 AM

Work Order ID: 124754

124754

Parent Item: D3192-042

D3192-042

Parent Item Name: Pod Assembly

Start Date: 9/23/14

Required Date: 10/31/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

150

Each

4,609.000

21

21

NAS1149D0463.J

WASHER

DAS
27

~~8-89~~

11/12/12

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

4124

113706

1

16941

8

M126221

20

M127813

6

M127904

16

M128591

44

M128995

1500

M129390

2529

M130799

21

NAS1149DN632J

Purchased

No

150

Each

403.0000

2

2

NAS1149DN632.J

Washer

DAS
27

~~8-89~~

11/12/12

Location

Loc Qty

Loc Code

CA

46

M129682

46

ST277

357

M126084

11

M127255

100

M128812

246

2

ITEM	Qty -041	Qty -042	PART NUMBER	DESCRIPTION
1	X		D3192-041	UTILITY POD ASSEMBLY, LH
2		X	D3192-042	UTILITY POD ASSEMBLY, RH
5			D3192-1	DELETED AT REVISION C
9	1	1	D2195	BRACKET
10	1	1	D2196	BRACKET
11	1	1	D2197	BRACKET
12	6	6	D2193-1	BRACKET
13	1	1	D2200-1	POD LID
14	1	1	D2200-3	POD BASE
15	3	3	D2204-6	LATCH
16	2	2	D2204-9	LATCH
17	1	1	D2195-210	PLACARD
18	1	1	D2193-041	SPRING CLIP ASSEMBLY
19	1	1	D2193-1700	NEOPRENE SEAL
20	5	5	D2523-1	EACHER PLATE
21	4	4	D2523-3	EACHER PLATE
30	1	1	D3007-041	PROP ASSEMBLY
31	2	2	D3191-1	EACHER PLATE
32	3	3	D3191-3	EACHER PLATE
33	1	1	D3191-5	EACHER PLATE
34	1	1	D4390-17	PIANO HINGE
40	30	30	AN3-MAB5	RIVET
41	30	30	AN3-11A	BOLT
42	30	30	AN3-5A	BOLT
43	6	6	AN3-11A	BOLT
44	13	13	AN3-5A	BOLT
45	1	1	AN3-2A	BOLT
46	2	2	AN3280602R7	SCREW
47	60	60	AN360JD10	WASHER
48	21	21	AN360JD116	WASHER
49	2	2	AN360JD6	WASHER
50	2	2	MS21042L06	NUT (OR MS21042-06)
51	60	60	MS21042L5	NUT (OR MS21042-5)
52	20	20	MS21042L4	NUT (OR MS21042-4)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER PART 081 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 54 LBS APPROX.
- 8) SEAL ALL HOLES AND EDGES OF POD LID (ITEM 13) AND BASE (ITEM 14) WITH CYANOACRYLATE GLUE.
- 9) FOR INSTALLATION OF D4390-17 HINGE:
 - (i) TRANSFER MARK AND DRILL POD LID (ITEM 13) AND BASE (ITEM 14) Ø0.191.
 - (ii) INSTALL RIVET HEADS FROM OUTSIDE OF POD.
 - (iii) GRIND TRAILING EDGE OF RIVET TO 0.100 IN HEIGHT TO PERMIT HINGE TO CLOSE.
- 10) FOR HOLES DRILLED THROUGH FOAM CORE:
 - a) DRILL Ø0.312" HOLES THROUGH POD.
 - b) CLEAN OUT FOAM 20.250" AROUND HOLE BETWEEN INNER AND OUTER SHINS.
 - c) APPLY TAPE TO UNDERSIDE OF SHIN (TO STOP EPOXY FILLER GOING THROUGH).
 - d) FILL CAVITY BETWEEN SHINS COMPLETELY WITH "HYSCOL EA934" OR SIMILAR EPOXY PUTTING COMPOUND.
 - e) AFTER THE EPOXY HAS COMPLETELY CURED, DRILL Ø0.257 FINISH HOLE SIZE FOR AN3 BOLT OR Ø0.191 FINISH HOLE SIZE FOR AN3 BOLT.
- 11) RELIEVE D2200-1 POD LOCALLY IN AREA OF D2195/D2196/D2197 BRACKETS TO CLEAR BRACKETS.
- 12) INSTALL D3191-1/3/5 EACHER PLATE USING SHARPLEX 3014/301 ADHESIVE.

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 124954 MLS
1409-23

RELEASED
2011-05-28

C	ADDED SHT 5. MOVED VIEWS FROM SHT 4 TO SHT 5. SHT 1 DELETED ITEM 5. ADDED ITEM 14. SHT 4 ADDED DETAIL G & DETAIL H. (SEE CAP 11-030).	AJS	11.05.05
B	DRAWING TRANSFERRED TO "D" SIZE AND REDRAWN WITH CURRENT STANDARDS. - 1 HINGE ADDED. ADDED ITEM 33 (SEE NCR 09-110).	AJS	09.01.05
A	NEW ISSUE	DS	03.07.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	UNITS
DATE	11.05.05	COPYRIGHT © 2003 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

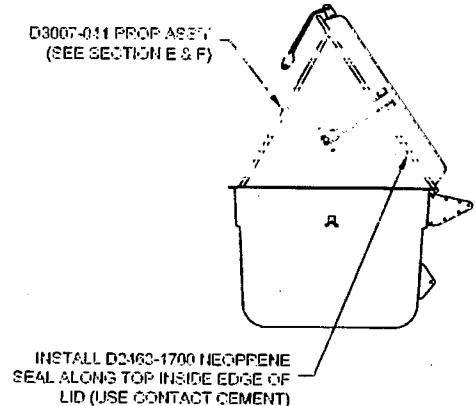
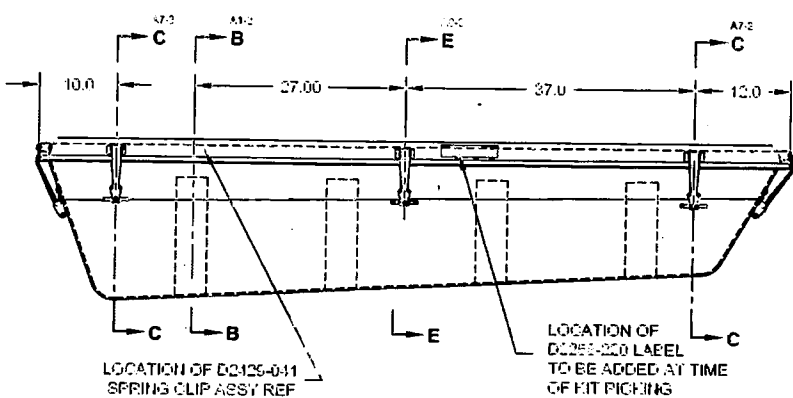
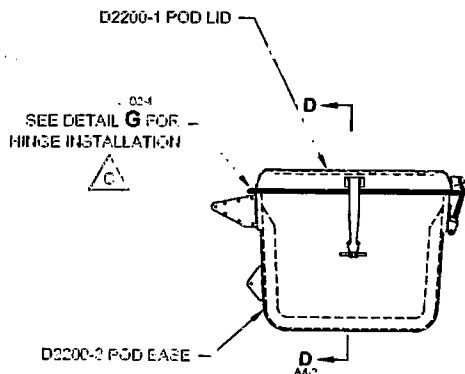
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

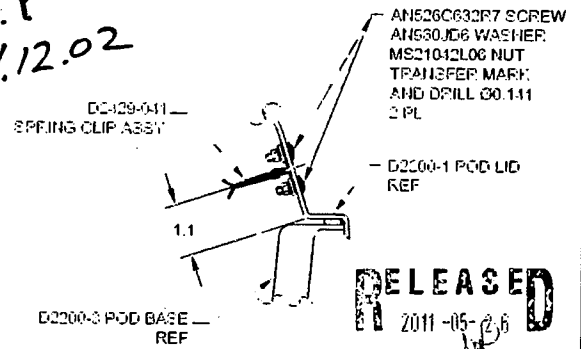
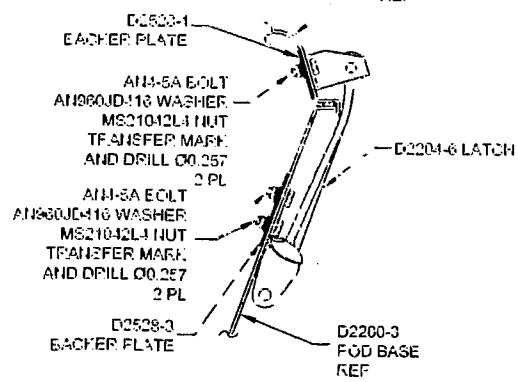
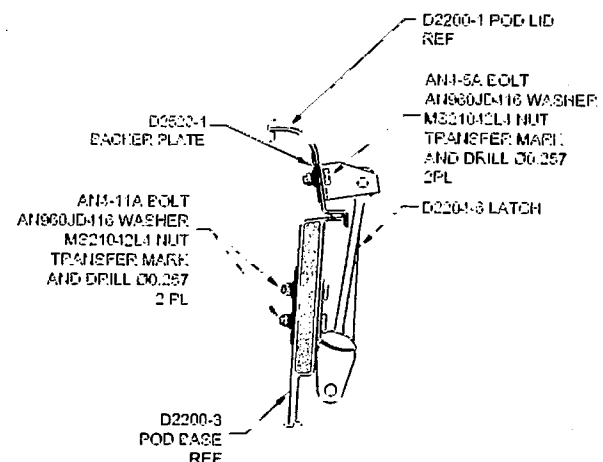
FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Fink/Fipple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Curge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



D3192-041 UTILITY POD ASSEMBLY, LH (SHOWN)
D3192-042 UTILITY POD ASSEMBLY, RH (OPPOSITE)

RH A.P. 14.12.02



SECTION B-B
SCALE 6X

DESIGN	D3	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	UTS
DATE	11.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD	

RELEASED
R 2011-05-26

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

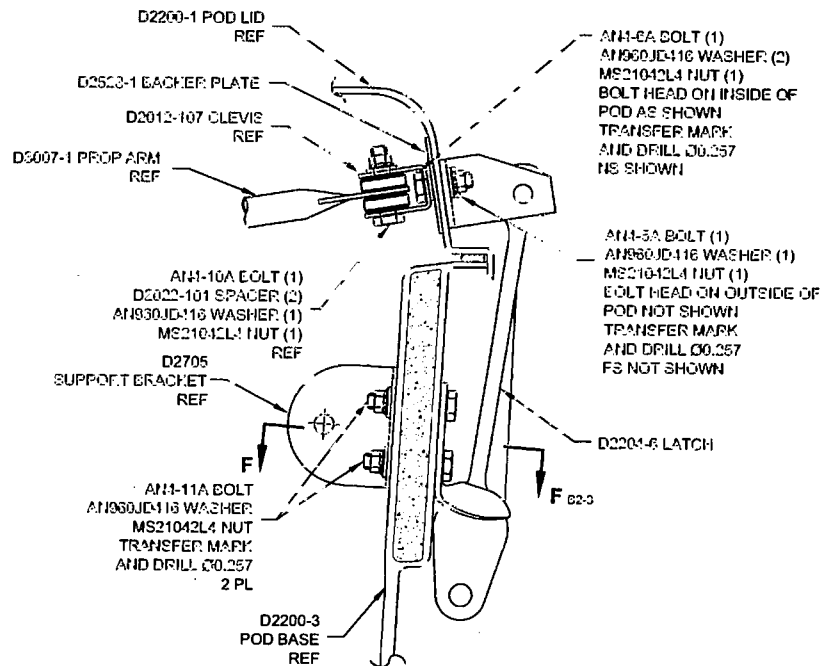
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

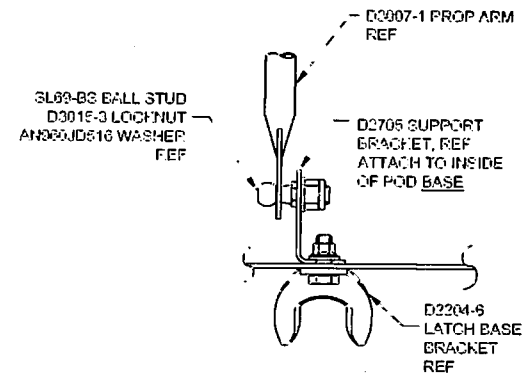
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Curge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



SECTION E-E D4-2



SECTION F-F C5-3
ROTATED C5° CW

RELEASED
2011-05-26

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	11.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS FURNISHED FOR YOUR INFORMATION ONLY. IT IS NOT TO BE USED FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

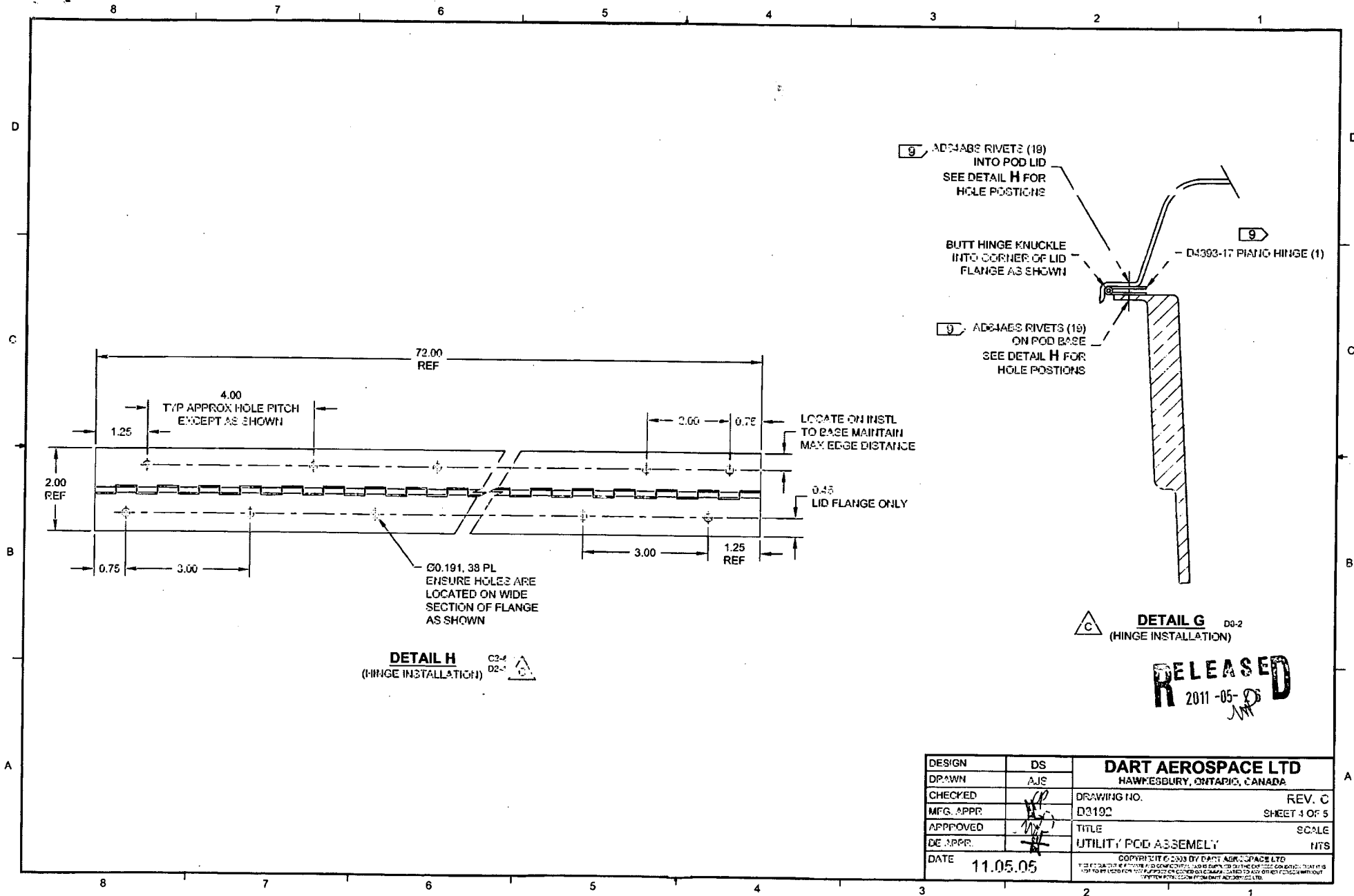
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;">Skid-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/>									
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Handling/Pre <input type="checkbox"/>									
Material <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Offset/Setup <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Hink/Fipple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--



RELEASED
2011-05-08
JMT

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3192	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	11.05.05	COPYRIGHT © 2005 BY DART AEROSPACE LTD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

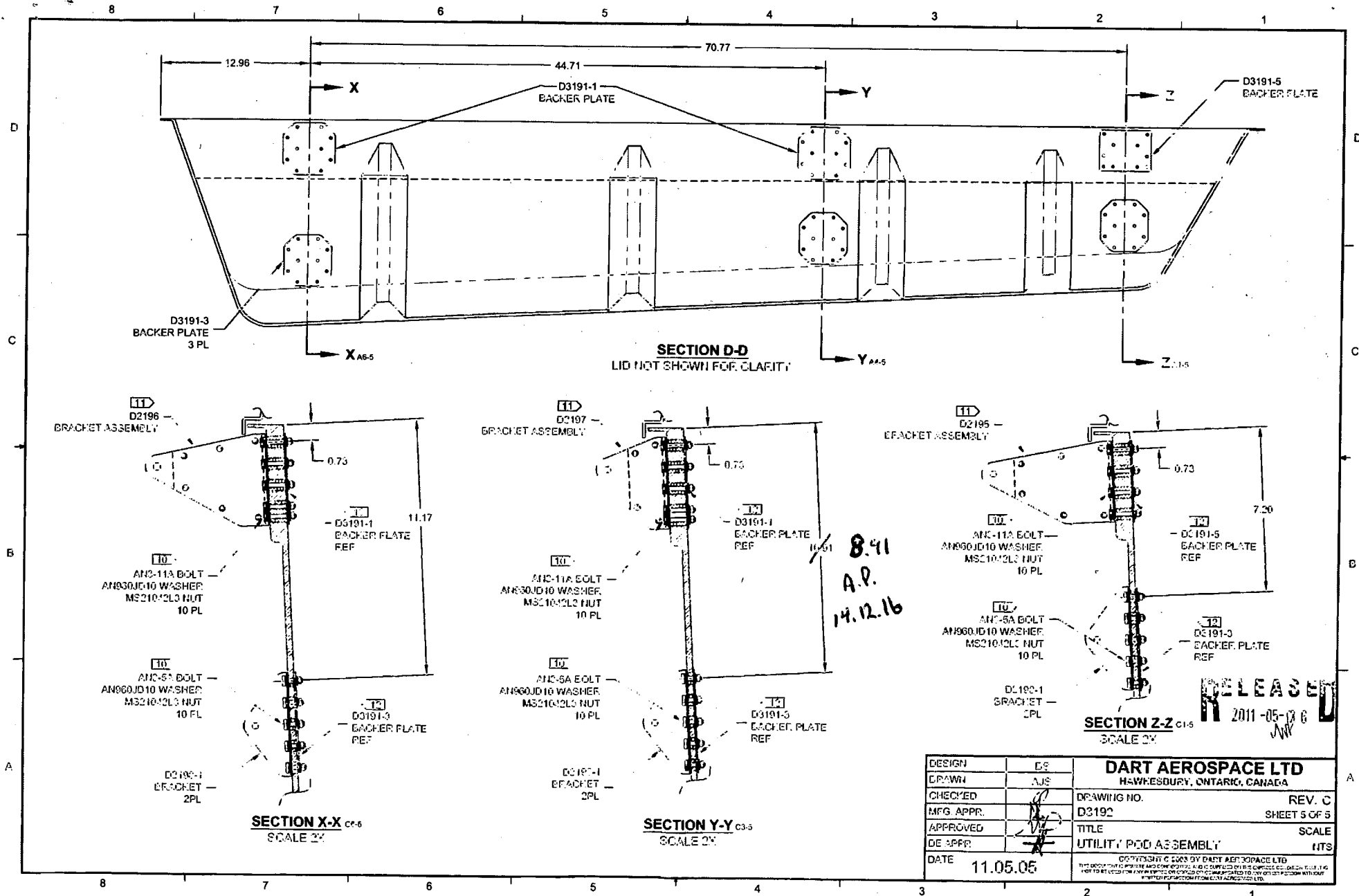
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Hink/Fipple/Wave <input type="checkbox"/> Cuff <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Curge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other: _____ _____ _____ _____
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<table style="width: 100%;"> <tr> <td style="width: 33%;"> AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Transport <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Curge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--	--

NOTES:

1) MATERIALS:

RESIN: EPOCAST 80-A/9016 OR DEPAKANE 470-38/411/510/40

FOAM: A590 CORE-CELL, OR DIVINYCELL, OR FLEGECELL, OR
AIREX, 0.36 THICK (3/32" FOAM)

FIBER: 9.7oz 7701 WEAVE "S" GLASS (9oz SATIN)
5oz PLAIN WEAVE KEVLAR (5oz KEVLAR)
12oz UNIDIRECTIONAL (12oz UNIDIRECTIONAL)
OWENS CORNING MILLED FIBERS, "E" GLASS

FILLER: MIXTURE OF RESIN AND MILLED FIBERS

EXPANDING FOAM: DEMILEC E352-01/A100-4 (LIQUID FOAM)

2) FINISH: -INSIDE: DUPONT HIGHBUILD GREY PRIMER 7704S
-OUTSIDE: WHITE GELCOAT GEL 944W005

3) TOLERANCES: PER DART QSI 010 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK: SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 005
LAMINATION SCHEDULE PER THIS DRAWING.

9) PEEL PLY ALL SURFACES.

RELEASED
2011-05-26

C	SHT 3, ZONE D5 DIM WAS 63.0, ZH D5 DIM WAS 27.0, ZH D5, MOLD DATUM BELCOATED TO FIXED POINT FOR CLARITY. (SEE CAR 10-20)	AJS	11.04.20
B	DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 1 EXPANDING FOAM MATERIAL WAS GELCOTE VULTAFOAM W9800 A/B, FINISH SPEC UPDATED. MULTIPLE DIMS ON MULTIPLE SHEETS CHANGED FROM REF TO "HARD" CALLOUTS. SHT 2 D2200-7 WAS D2200-7 (TYPO). VIEWS FROM SHT 5 TRANSFERRED TO SHT 4. D2200-7 DETAILED ON SHT 5.	AJS	08.09.16
A	NEW ISSUE	JB	03.05.21
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	ITS
DATE	11.04.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. NO PART OF THIS DRAWING IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING BY DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

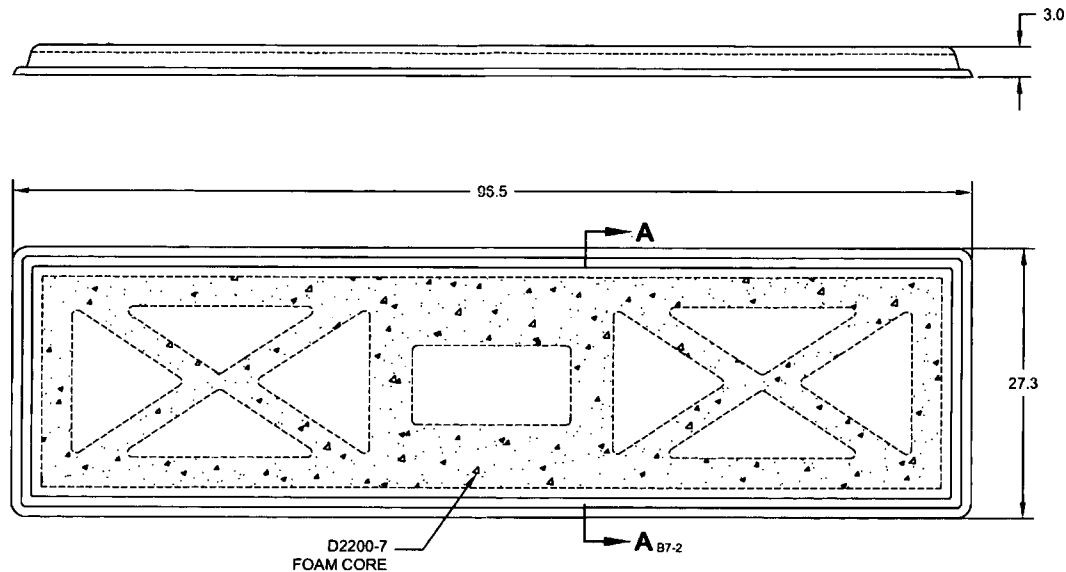
C

B

A

SECTION A-A B4-2

DETAIL B B1-2

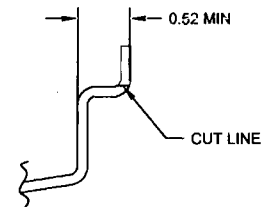


D2200-7
FOAM CORE

D2200-1 LID (MOLD DT8007)

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
D2200-7 FOAM CORE
5oz KEVLAR
9oz SATIN



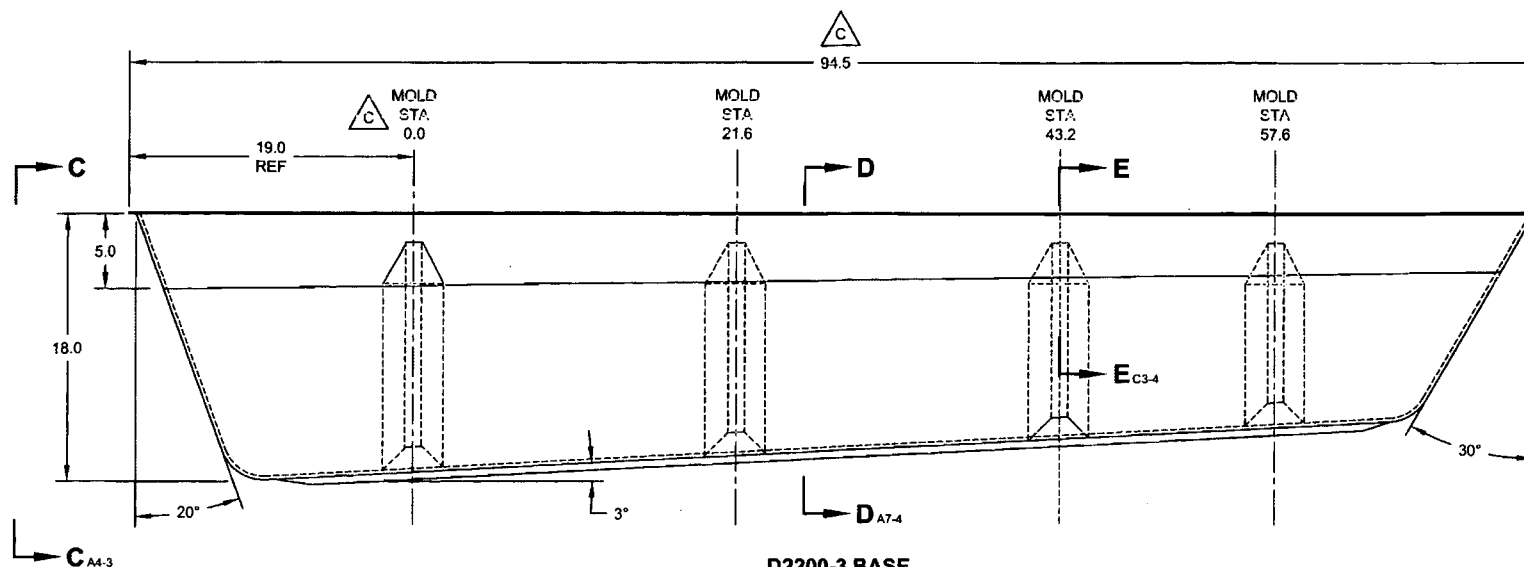
DETAIL B B4-2
SCALE 10X

RELEASED
2011-05-26
JW

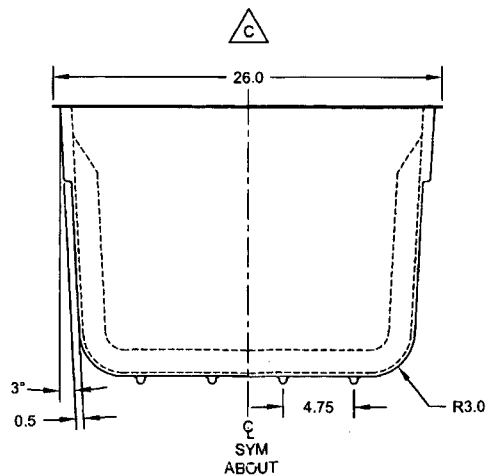
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D2200	SHEET 2 OF 5
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	UTILITY/ POD LID AND BASE (212)	NTS
DATE	11.04.20	COPYRIGHT © 2005 BY DART AEROSPACE LTD ALL RIGHTS RESERVED. THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D2200-3 BASE
(MOLD DT8001)



VIEW C-C C0-3

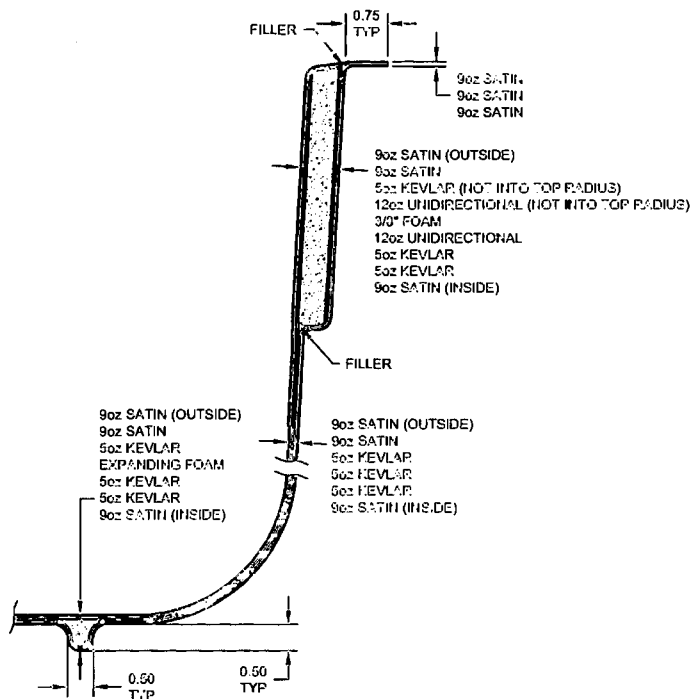
RELEASED
2011-05-26

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. C
MFG. APPR.		D2200	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	NTS
DATE	11.04.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED IN THE ORDER AND NOT FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

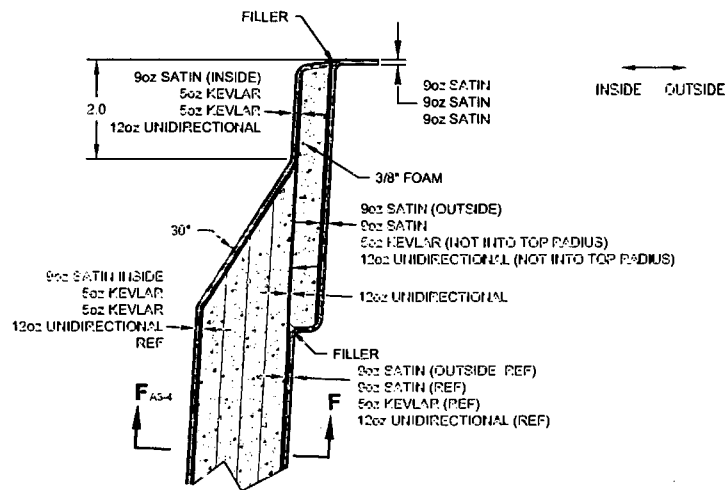
8 7 6 5 4 3 2 1

6 7 6 5 4 3 2 1

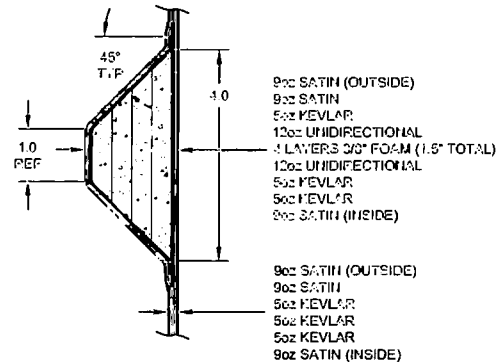
INSIDE OUTSIDE



SECTION D-D C4-3
(PART SECTION OF WALL SHOWN)



SECTION E-E C3-3
(PART SECTION OF WALL SHOWN)

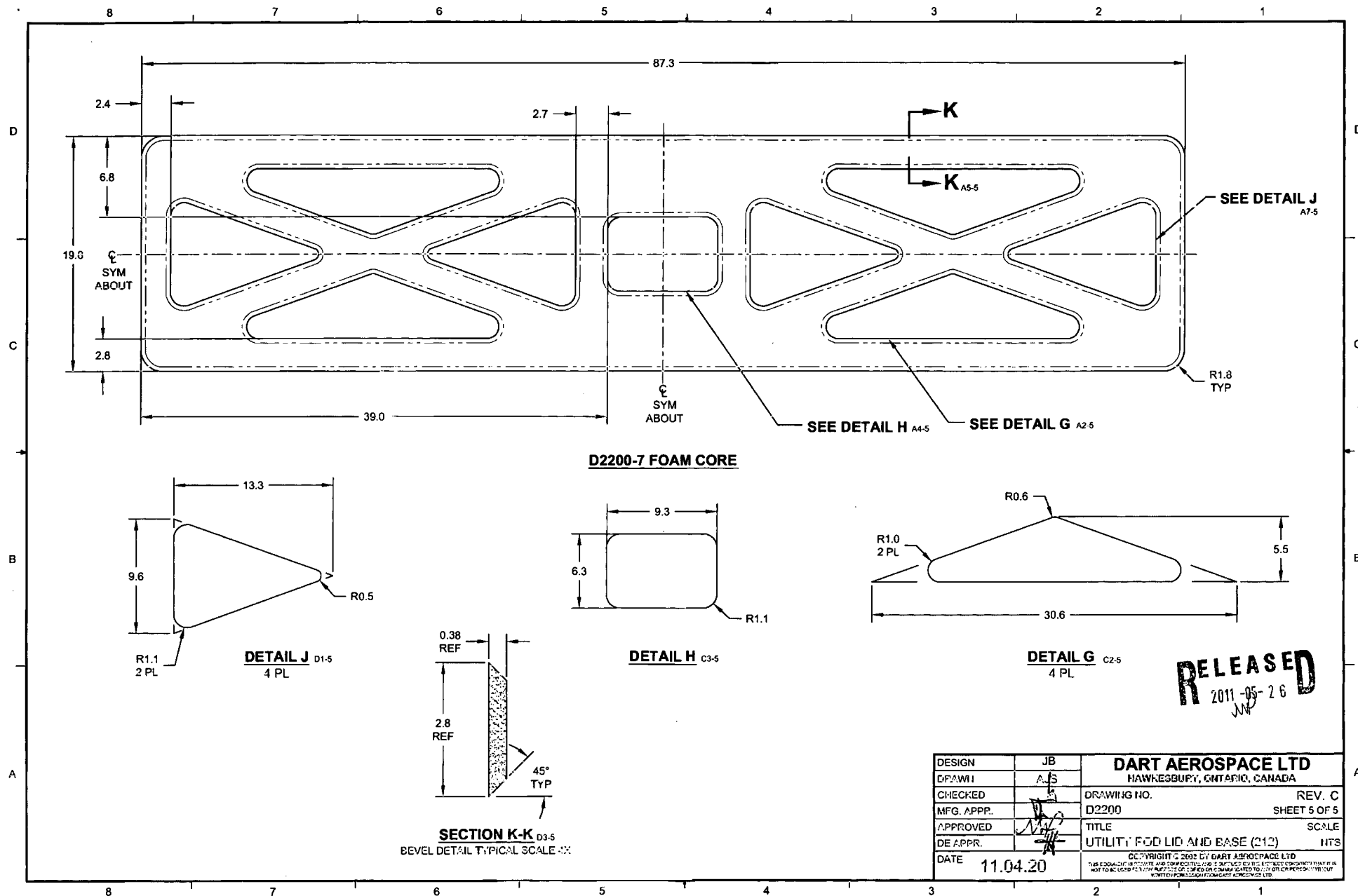


SECTION F-F C4-4

RELEASED
2011-05-26

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	SJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	H	DRAWING NO.	REV. C
MFG. APPR.		D2200	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD LID AND BASE (212)	HTS
DATE	11.04.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD	

8 7 6 5 4 3 2 1





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25888**

Purchase Order Date 9/23/2014

PO Print Date 9/23/2014

Page Number 1 of 2

Order From :

DELASTEK INC
2609 SE AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID

Contact Name

Vendor Phone 819 533 5788

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

USD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2200-1P AS PER DWG D2200 REV. C B124754	Pod Lid	11/28/2014 Yes 11/28/2014		1.00 Each <i>rel 11/21/14 SD</i>	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
2	D2200-3P AS PER DWG D2200 REV. C B124754	Pod Base	11/28/2014 Yes 11/28/2014		1.00 Each <i>rel 11/21/14 SY</i>	\$2,890.60	\$2,890.60
Line Total:							\$2,890.60
3	D2200-1P AS PER DWG D2200 REV. C B124755	Pod Lid	12/23/2014 Yes 12/23/2014		1.00 Each	\$2,890.60	\$2,890.60

Note:

9/23/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	58864
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawthornbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Dale Bates

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawthornbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577

Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
25-11-2014	24-09-2014	25021	Chantal Lavoie	PO25833	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
Day & Recs Collect	Point de départ	Melody Shapcott, ext. 235			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0079 14121 SV	Line #1 D2200-1 Utility Pod Lid (212) B124754 DWG: D2200 REV. C DOCUMENT INCLUS Serial # Lot # B124754 64580	U of M: Chaque
1	0	1	DKC134-0080 14121 SV	Line #2 D2200-3 Utility Pod Base (212) B124754 DWG D2200 REV. C Réf.: DK-362 Serial # Lot # B124754 64581	U of M: Chaque

8p14-11-12.

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

[Signature]
Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2011-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE

Numéro Job : 04581

Numéro : 5184

Numéro B.A. :

Cette fois : 2014-09-25 No. :

Prsht Rev. : NC

Prem. fois : - - Type :

Job précédente : 43686

Écrit par : 

Vérifié & Approuvé par : _____

Commentaires : N° de dessin: 2200-3 rev. C

Nom Dessin : D2200-3 UTILITY POD BASE (312)

Numéro Article : DKC134-0080

Numéro Dessin : -

Projet Numéro : DK-362

Révision dessin :

Matériel : Composite

Date Due : ~~2014-10-02~~

Qté: 1 Ud UNITE

2014-11-28

B 124754



COPIE

E.O.: N/A

Feuille de Procédé Rév.: 01 AMB0249 remplacé par
AMB0511 (réf. RFC #228)

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 4802810AA

2.0 PEEP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Fun: 15.0000Min Total Run: 0.2500Hrs

Faire la préparation du moule # DT8001 selon IG 0009.

Date: 21/10/14



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.500 FILOGRAMME(s)/Unit Total: 0.500 FILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 4793110AA

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0800 GALLON(s)/Unit Total: 0.0800 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

5.0 GEL COAT Application du Gel Coat



Comment Setup: 0.00Hrs/ Fun: 20.0000Min Total Run: 0.3333Hrs






Préparer et appliquer le Gel Coat selon IG 0019.

Date: 21/10/14















Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: D2300-3 UTILITY POD BASE (212)	
Numéro Job: 64581	Numéro DKC134-0080	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
6.0	AMB0014	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Comment	Qty.: 20.00 VERGE(s)/Unit Total : 20.00 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	N° de Lot: <u>1-49418-1</u>
7.0	AAC1608	5oz plain weave Kevlar 50" wide roll
Comment	Qty.: 14.00 VERGE(s)/Unit Total : 14.00 VERGE(s) 5oz plain weave Kevlar 50" wide roll	N° de Lot: <u>1-42765-1</u>
8.0	AMB0511	N° TG-13-U, Fiberglass 13 oz
Comment	Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s) N° TG-13-U, Fiberglass 13 oz	N° de Lot: <u>1-36302-1</u>
9.0	PREP-GENERAL	Préparation du matériel
 		
Comment	Setup: 0.00Hrs/ Run: 80.0000Min Total Run : 1.0000Hrs Tailler le matériel suivant selon les dimensions requises : Fibre 9.7 oz, deux bandes servants à couvrir le fond du moule. Fibre 9.7 oz, quatre bandes servants à couvrir les deux bouts en pentes. Fibre 9.7 oz, quatre bandes servants à couvrir les deux côtés du moule. Fibre Kevlar 5 oz, une bande servant à couvrir le fond du moule Fibre Kevlar 5 oz, deux bandes servants à couvrir les deux bouts en pentes. Fibre Kevlar 5 oz, deux bandes servants à couvrir les deux côtés du moule. Fibre 13 oz, deux bandes servant à couvrir les deux côtés supérieur du moule selon le sketch de Dart reçu le 21/5/2013 Date: <u>16-10-14</u> Sceau:  	
10.0	AAC1825	Tissu à délaminer Release ply B
Comment	Qty.: 21.67 VERGE(s)/Unit Total : 21.67 VERGE(s) Tissu à délaminer Release ply B	# de Lot: <u>N/A</u>
11.0	AAC1897	Wrightlon 5200 Bleu P3
Comment	Qty.: 23.92 VERGE(s)/Unit Total : 23.92 VERGE(s) Wrightlon 5200 Bleu P3	# de Lot: <u>N/A</u>
12.0	AC0085	Faute de drainage N° Airweave N 10
Comment	Qty.: 20.00 VERGE(s)/Unit Total : 20.00 VERGE(s)	
13.0	AC0086	Ruban à gommer jaune #: T/AT-200Y
Comment	Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)	
14.0	AC0943	Sirstichlon 200 poche à vide Vert
Comment	Qty.: 20.00 PIED(s)/Unit Total : 20.00 PIED(s)	














Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY POD BASE (212)
Numéro Job:	64581	Numéro	DKC134-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
15.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs		
	Préparer le matériel pour la poche à vide.		
	Tissu à délaminer 1.5M de large Film Durisol Perforé P-3 Feutre drainage Ruban à gommer jaune Poche à vide Vert		
	Date: <u>16-10-14</u> Sceau: 		
16.0	AMB0236	Catalyst N° DDM-9	
Comment	Qty.: 0.0600 GALLON(s)/Unit Total: 0.0600 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
17.0	AMB0212	Résine (41157530) 411-350 promo. 75min.	
Comment	Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s) Résine (41157530) 411-350 promo. 75min N° de Lot: <u>4176810AB</u>		
18.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Préparer le mélange de résine selon les quantités requises. Mix ratio 1.5% de catalyst DDM-9 par quantité de résine 411-350.		
	Date: <u>22/10/14</u> Sceau: <u>4102 N.T 4297 A.M</u>  		
19.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 270.0000Min Total Run : 4.5000Hrs		
	À l'aide d'un rouleau à peinture dis. 2", appliquer une bonne couche de résine 411-350 sur toutes les surfaces du moule. Laminer le premier pli de 9.7 oz.		
	Recommencer la même étape pour le deuxième pli de 9.7 oz, encore une fois pour le pli de Kevlar 5 oz et une dernière fois pour les deux bandes de 13 oz mais seulement sur les cotés supérieurs.		
	Date: <u>22/10/14</u> Sceau: <u>4102 N.T 4297 A.M</u>  		













Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY POG BASE (212)
Numéro Job:	64501	Numéro	DKC134-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
	Appliquer la poche à vide selon IG 0012.		
Date:	22/10/14 4102 N.T 4297 A.M  		
21.0	AAC1398	N° Demilec B352-0/A100-4, Pourable Rigid Foam	
Comment	Qty.: 0.016 KIT(s)/Unit Total: 0.016 KIT(s)		
	N° Demilec B352-0/A100-4, Pourable Rigid Foam N° de Lot: 48435/0AA		
22.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs		
	Mesurer pour chaque rainure 100 g de partie A de Demilec et 100 g de partie B de Demilec. Bien mélanger les deux produits et couler doucement dans les rainures.		
	Laisser durcir 1 heure puis tailler pour égaliser la mousse avec le fond de la pièce.		
	Sceller la mousse selon IG 0105.		
Date:	30/10/14  		
23.0	AMB0375	ATC core-cell A500 plain 4'x8' 3/8" thick	
Comment	Qty.: 1.000 FEUILLE(s)/Unit Total: 1.000 FEUILLE(s)		
	ATC core-cell A500 plain 4'x8' 3/8" thick N° de Lot: 46879/0AA		
24.0	TAILLAGE	Faire le taillage du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Tailler le Foam Core A-500 3/8" tel que décrit sur le dessin D2200.		
Date:	30/10/14  		
25.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0135 GALLON(s)/Unit Total: 0.0135 GALLON(s)		
	Catalyst N° DDM-9 # de lot: 1-27829-1		
26.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s)		
	Résine (411B7530) 411-350 promo. 75min. # de lot: 47950/0AB		


















Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY POD BASE (212)
Numéro Job:	64581	Numéro	DKC134-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
27.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
	Préparer la résine et sceller le foamecore selon IG 0105.		
Date:	30/10/14	Scieur:	
28.0	AAC1811	Polybond B46F	
Comment	Qty.: 1.000 KIT(s)/Unit Total : 1.000 KIT(s) Polybond B46F N° de Lot: 1-40597-1		
29.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs		
	Préparer le polybond, l'appliquer ainsi que le foamecore selon le dessin, et faire la poche à vide selon IG 0033.		
Date:	30/10/14	Scieur:	 
30.0	AME0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.500 FILOGRAMME(s)/Unit Total : 1.500 FILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4849210AA		
31.0	AME0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0510 GALLON(s)/Unit Total : 0.0510 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
32.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Tailler deux bandes de 7" de large de Fibre 13 oz pour couvrir le core tel que décrit sur le dessin D2200		
	Préparer le mélange de Résine selon les quantités requises. Mix ratio 1.5% de catalyst DDM-9 par quantité de résine 411-350.		
	À l'aide d'un rouleau à peinture dia. 2", appliquer une bonne couche de résine 411-350 sur toutes les surfaces des cores. Laminer la bande de Fibre 13 oz.		
Date:	31/10/14	Scieur:	 
















Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY FOD BASE (212)
Numéro Job:	64581	Numéro	DKC134-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs		
	Couper le foam core A-500 3/8" pour former les 4 sections transversales. Utiliser un " heat gun " pour former le core.		
	Préparer la résine et Sceller le 4 foamoeres selon IG 0105.		
	Coller les sections de core tel que décrit sur le dessin D2200 en utilisant du Polybond B46F selon IG 0033.		
Date:	7/11/14	Scellé:	 
34.0	AMB0210	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)		
	Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4849210AA		
35.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 270.0000Min Total Run : 4.5000Hrs		
	Sur chacune des sections transversales de core, laminier une bande de 13oz.		
	À l'aide d'un rouleau à peinture dia. 2", appliquer une bonne couche de résine 411-350 sur toutes les surfaces de la pièce. Laminer le premier pli de 5 oz Kevlar.		
	Recommencer la même étape pour le deuxième pli de Kevlar 5 oz.		
	Recommencer la même étape pour le pli de 9.7 oz 7781		
Date:	7/11/14	Scellé:	   
36.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
	Appliquer la poche à vide selon IG 0012 sur le moule en faisant bien attention qu'il n'y ai pas de fuite et laisser sécher pendant 12 heures minimum.		
Date:	7/11/14	Scellé:	   










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Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY POD BASE (212)
Numéro Job:	64581	Numéro	DKC124-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
37.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs Démouler la pièce Inspecter la pièce avec le dessin D2200. Date: <u>12/11/14</u> Sceau:  		
38.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run: 0.7500Hrs Effectuer le taillage du contour de la pièce selon le dessin D2200 Réparer toutes les imperfections à l'intérieur de la pièce à l'aide du P15-3. Date: <u>13/11/14</u> Sceau:  		
39.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4768450114</u>		
40.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabaze	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabaze N° de Lot: <u>4768410114</u>		
41.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Appliquer le primer selon I.G. 0008 AQ-1610346 Date: <u>13-11-14</u> Sceau: 		
42.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire le sablage au grit N° 120 de la surface primée pour enlever les imperfections restantes. Date: <u>19/11/14</u> Sceau: 		

Date: Jeudi, 2014-09-25 12:13:22
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-3 UTILITY POD BASE (212)
Numéro Job:	64581	Numéro	DRG134-0080
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
43.0	AAC1031	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4768450AA</u>		
44.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>		
45.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Appliquer le primer selon IG 0008. Date: <u>20/11/14</u> Sceau: <u>4232A</u>		
46.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Inspection finale par le département de la qualité (Visuelle) selon le dessin D2200. Date: <u>21-11-14</u> Sceau: 		
47.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Emballage et Entreposage selon IG 0057. Quantité: <u>1</u> Date: <u>24-11-14</u> Sceau: 		

Date: Jeudi, 2014-09-25 12:13:21
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE
Numéro Job : 64580
Numéro : 5103
Numéro B.A. :
Cette fois : 2014-09-25 No. :
Prsht Rev. : NC
Prem. fois : Type :
Job précédente : 64579

Nom Dessin : D2200-1 UTILITY POD LID (212)
Numéro Article : DKC134-0079
Numéro Dessin : 2200
Projet Numéro : DK-362
Révision dessin : C
Matériel : Composite
Date Dûe : 2014-10-02
Qté: 1 Ud UNITE

Écrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: 2200-1



B124754



Process Sheet Rév.: 00 Création du premier à partir du
DKC134-0026 Rév.: de Dessin B

Produit additionnel

COPIE















Numéro Job:



# Séq.:	Machine ou	Description :
1.0	AAC1016	N° 83634, Frakote Loctite Wolo
<p>Comment Qty.: 0.500 UNITE(s)/Unit Total : 0.500 UNITE(s) N° 83634, Frakote Loctite Wolo # de Lot: 4802810AA</p>		
2.0	FREP-GENERAL	Préparation du matériel
<p>Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Faire la préparation du moule N° DT8007 selon IG 0009. Date 27/10/14 Sceau: </p>		
3.0	AMB0050	Gel Coat Blanc N° Gel 944W005
<p>Comment Qty.: 0.250 KILOGRAMME(s)/Unit Total : 0.250 KILOGRAMME(s) Gel Coat Blanc N° Gel 944W005 N° de Lot: 4793110AA</p>		
4.0	AMB0286	Catalyst N° DDM-9
<p>Comment Qty.: 0.0900 GALLON(s)/Unit Total : 0.0900 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1</p>		
5.0	GEL COAT	Application du Gel Coat
<p>Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs Préparer et appliquer le Gel Coat selon IG 0019. Date 27/10/14 Sceau: </p>		

Date: Jeudi, 2014-09-25 12:13:21
Utilisateur: marc dubé










Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	02200-1UTILITY POD LID (212)
Numéro Job:	64580	Numéro	DKC134-0079
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
Date: 24/09/14 			
14.0	AMB0212	Résine (411E7530) 411-350 promo. 75min.	
Comment	Qty.: 1.500 FILCIGRAMME(s)/Unit Total: 1.500 FILCIGRAMME(s) Résine (411E7530) 411-350 promo. 75min. N° de Lot: 4776210AR		
15.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0510 GALLON(s)/Unit Total: 0.0510 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-277229-1		
16.0	PREP-GENEPAL	Préparation du matériel	
 			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté N° RV411B3020. Date: 27/10/14  		
17.0	LAMINAGE	Faire le laminage	
 			
Comment	Setup: 0.00Hrs/ Run: 12.0000Min Total Run: 0.2000Hrs Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante: Recouvrir toute la surface du moule N° DT8007 à l'aide de de résine Derakane 411-350 Promoté N° RV411B3020. Ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin) Recommencer pour les deux autres plis (un pli de 9 oz et un pli de 5 oz Kevlar) Date: 27/10/14  		
18.0	BAGGING	Faire le bagging sur la pièce	
 			
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run: 0.3333Hrs Faire la poche à vide sur le moule N° DT8007 selon IG 0012. Date: 27/10/14  		

Date: Jeudi, 2014-09-25 12:13:21










Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2300-UTILITY POD LID (212)
Numéro Job:	64580	Numéro	DKC134-0079
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
19.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0135 GALLON(s)/Unit Total: 0.0135 GALLON(s) Catalyst N° DDM-9 # de Lot: 1-27829-1		
20.0	DKC134-0065	N° D2300-7 Foam Core (Utility Pod Lid)	
Comment	Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) N° D2300-7 Foam Core (Utility Pod Lid) N° de Job: 64584		
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 0.400 KILOGRAMME(s)/Unit Total: 0.400 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. # de Lot: 4798010AB		
22.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Préparer la résine et Sceller le foam core selon IG 0105. Quantité: 1 Date: 30-09-14 Scellé: 		
23.0	AAC1611	Polybond B46F	
Comment	Qty.: 1.000 KIT(s)/Unit Total: 1.000 KIT(s) Polybond B46F N° de Lot: 1-40397-1		
24.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs Préparer le polybond, l'appliquer ainsi que le foamcore selon le dessin, et faire la poche à vide selon IG 0033. Date: 29-10-14 Scellé: 		
25.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.500 KILOGRAMME(s)/Unit Total: 1.500 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 4798010AB		
26.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0510 GALLON(s)/Unit Total: 0.0510 GALLON(s) Catalyst N° DDM-9 N° de Lot: 1-27829-1		
27.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs Mélanger la quantité de résine désirée pour la laminage des deux derniers plis du Pod Base: 1.5% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté N° RV411B3020.		














Date: Jeudi, 2014-09-25 12:13:21
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-1UTILITY POD LID (212)
Numéro Job:	64590	Numéro	DKC134-0079
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: 29/10/14 Soeau: 73 56		
28.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs		
Faire le laminage des deux dernier plis de tissu (1 pli de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:			
Recouvrir toute la surface du moule N° DT6007 à l'aide de de résine Derakane 411-350 Promoté N° RV411E3020. Ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)			
Recommandes pour le dernier plis. (un pli de 9 oz)			
	Date: 29/10/14 Soeau: 73 56		
29.0	BAGGING	Faire le bagging sur la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs		
Faire la poche à vide sur le moule N° DT6007 selon IG 0112.			
Laisser sécher jusqu'au lendemain.			
	Date: 29/10/14 Soeau: 73 56		
30.0	DÉMOULAGE	Démoulage de la pièce	
			
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs		
Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la pièce.			
Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.			
	Date: 31/10/14 Soeau: 73 56		
31.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs		
Sabler légèrement toute la surface intérieure du pod à l'aide de papier sablé grit N° 120.			










Date: Jeudi, 2014-09-25 12:13:21
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	D2200-UTILITY POD LID (212)
Numéro Job:	64590	Numéro	DKC134-0079
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
<p>Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air.</p> <p>Date: <u>3/11/14</u> Sceau:  </p>			
32.0	TRIMAGE	Trimage	
 			
<p>Comment Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs</p> <p>Faire le trimage du Pod Lid selon le dessin Page 2 de 5 Détail B.</p> <p>Vérifier le trimage du pod.</p> <p>Date: <u>3/11/14</u> Sceau:  </p>			
33.0	AAC1021	Dupont Primer N° 7704S	
<p>Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>4763450AA</u></p>			
34.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
<p>Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>476841CAA</u></p>			
35.0	PRIMER	Application primer	
 			
<p>Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs</p> <p>Préparer et Appliquer le primer selon IG 0008.</p> <p>Date: <u>07-10-14</u> Sceau: </p>			
36.0	FINITION	Finition Générale	
 			
<p>Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs.</p> <p>Faire le sablage au grit N° 180 de la surface primée pour enlever les imperfections restantes.</p> <p>Date: <u>18-11-14</u> Sceau: </p>			
37.0	AAC1021	Dupont Primer N° 7704S	
<p>Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>46475-2</u></p>			

Date: Jeudi, 2014-09-25 12:13:21
Utilisateur: marc dubé

Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	E2200-1UTILITY POG LID (212)
Numéro Job:	64580	Numéro	DKC134-0079
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
33.0	AAC1101	N° 77753, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total: 0.5000 UNITE(s) N° 77753, Dupont Activator - Reducer Chromabase N° de Lot: <u>4768410AA</u>		
39.0	PRIMER	Application primer	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Préparer et appliquer le primer selon IG 0008. Date: <u>20/11/14</u> Sceau: <u>4232AA</u>		
40.0	INSPEC FINAL	Inspection finale	
			
Comment	Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin. Date: <u>21-11-14</u> Sceau: 		
41.0	EMBAL / ENTREPO	Emballage & Entreposage	
			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Emballage et Entreposage selon IG 0057. Quantité: <u>1</u> Date: <u>24-11-14</u> Sceau: 		

DOA:

Date: 15/03/26



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/03/26

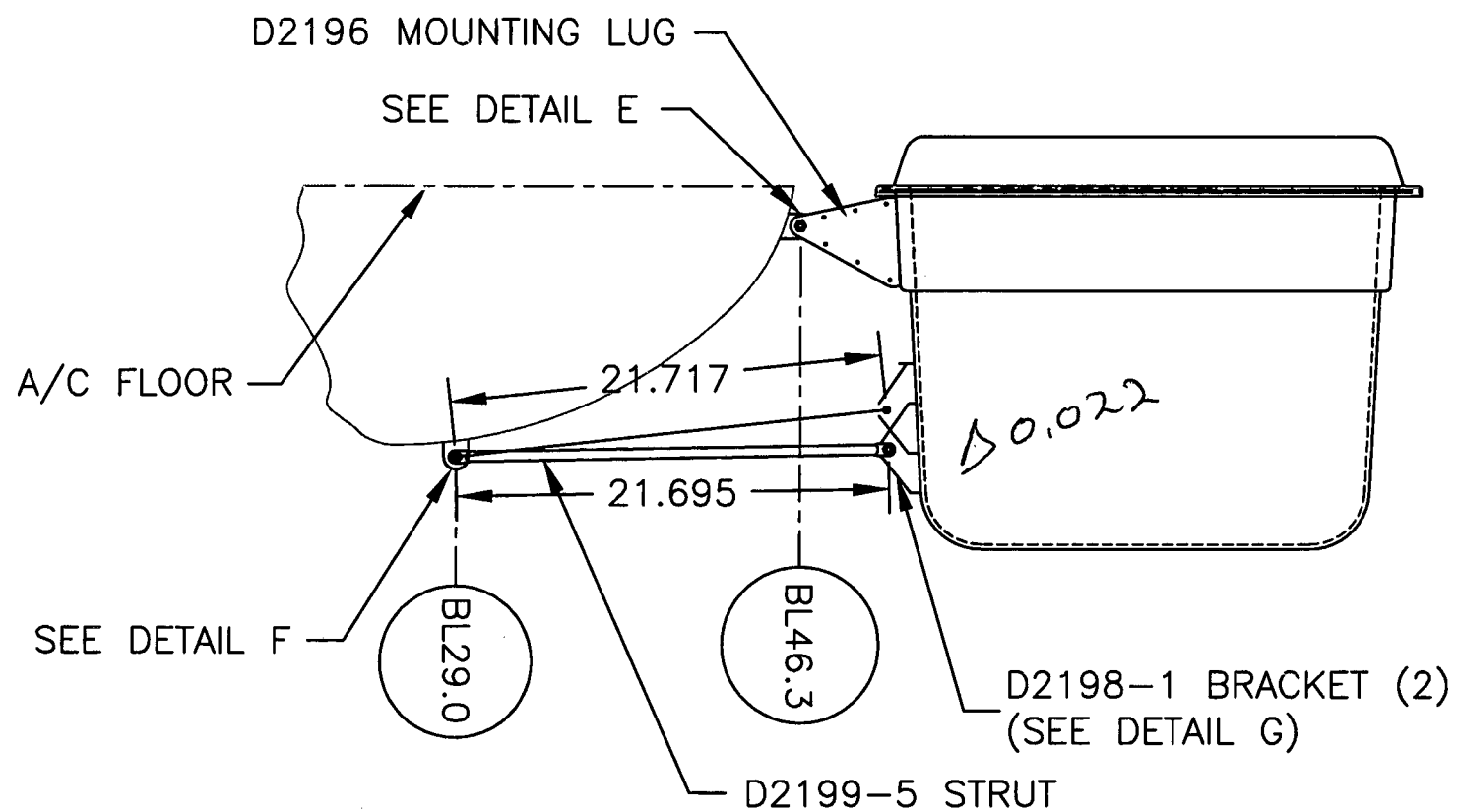
Work Order update only ☐

Work Order: <u>124754</u> Part No. <u>123192-042</u> NCR No. <u>15-4720</u>	DISPOSITION Rework: <input checked="" type="checkbox"/> Scrap: <input type="checkbox"/> Use-as-is: <input type="checkbox"/> Suspected Unapproved: <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube: <input type="checkbox"/> Crosstube: <input type="checkbox"/> Machining: <input type="checkbox"/> Small Fab: <input type="checkbox"/> Thermoforming: <input type="checkbox"/> Finishing: <input type="checkbox"/> Large Fab: <input type="checkbox"/> Composite: <input type="checkbox"/> Water Jet: <input type="checkbox"/> Engineering: <input type="checkbox"/> Prod. Eng. Coord.: <input type="checkbox"/> Quality: <input type="checkbox"/> Rec/Store/Packaging: <input type="checkbox"/> Other: <input type="checkbox"/> Supplier: <input checked="" type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14.12.16	130	1	DIMENSION (B4-S) WILL CAUSE D3191-3 WACKER PLATE TO HANG OVER BOTTOM OF POD RAD	A.P.	DEM D3.91 SHOULD USE S.91, MODIFICATION RESULTS IN A LENGTH Δ FOR INSTALLATION RAD OF 0.022 IN	<input checked="" type="checkbox"/>	5	8
Doc/Data					14.12.16	NO EFFECT ON INSTALLATION	15/03/26	15/01/12	15/01/12
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input checked="" type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Curge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DOA: Chit Date: 15/03/26QA Closed: RAM Date: 15/03/26

Work Order: <u>124751</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>123192-042</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>15-4721</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input checked="" type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Linda Lacelle

From: Jean-Luc Menard
Sent: December-22-14 10:27 AM
To: Linda Lacelle
Subject: PE: shims

PROG IS IN APP/DXXX-XXX-XXX/D212-205 CUSTOM SHIM.

Make them out of 3/8, we will need to face them to size.

JL

From: Linda Lacelle
Sent: December-22-14 9:54 AM
To: Jean-Luc Menard
Subject: shims
Importance: High

Hi JL,
Per note 13, we require 4 shims to be cut on the wj - 6061T6 alum
1each:
.348
.369
.166
.168
With hole .261 in the middle
Can you program this asap...customer is picking the pod up tomorrow

Thx

Linda Lacelle
Production manager

DART AEROSPACE
T 1-613-632-5200 Ext: 235

+ " x "

M6061T6 B0.375" x 3.00"

M124443.

Qty: (4)

0.375 x

DATE: 11.12.8564.
GREY SANDTEX

14-12-23.
START: 8:10
QWEN: T10200
FINISH: 840.

DAS 34 9.89